MA-6 Installation manual

A table of contents

1. Checking installation condition before installing machine
(1) Installation condition

2. Machine installation and checking condition of external appearance
(1) Fixing a machine.
(2) Checking X-Frame movement whether there is any interruption or

3. Machine motion TEST and Running Test.

4. Checking and adjusting needle position.

5. Checking and adjusting Hook setting condition.

6. Checking and adjusting height of Presser foot.

7. Checking and adjusting Upper and bottom dead point of needle bar.

8. TEST work with material.

1.Checking installation condition before installing machine

(1) Installation condition.

1) Temperature.
When machine work : 0。~40。C (32。~104。F)
When machine doesn't work (maintenance) : －25。~55。C (－13。~131。F)

2) Humidity
Humidity : 45~85%

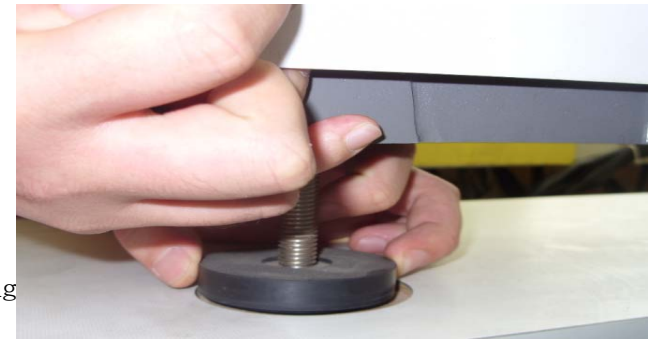
3) Surrounding condition
Please close window and entrance door to prevent sun light and moisture and dust from coming to machine.

4) Installation place.
Please install machine on flat ground as well as ground is concrete structure which is enough to bear machine weight without bumpy.

5) Main power : 1Ø 100~240V 50~60Hz ±10%

2. Machine installation and checking condition of external appearance

(1) Fixing a machine.



- Without exclusive stand

In case not using exclusive stand,

please adjust level on all posions

(lift-right, front-back) with level adjusting

- With exclusive stand

In case using exclusive stand,

fixing machine on stand table.

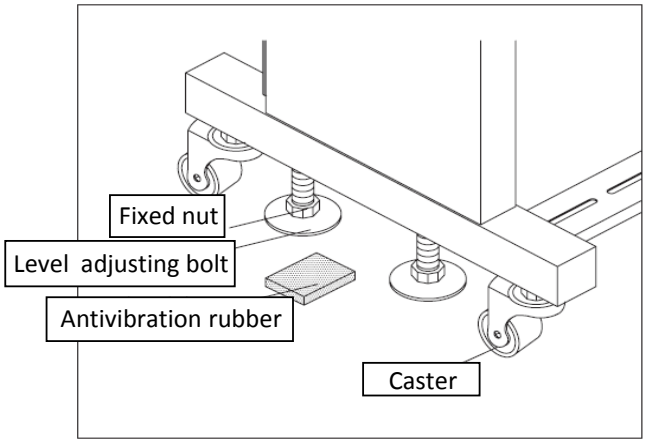
4 antivibration rubbers are placed under

under level adjusting bolt and adjust level

adjust bolt until caster is over ground.

Left and right and front, back of machine

should level off as using level gauge.



(2) Checking X-Frame movement whether there is any interruption or not.

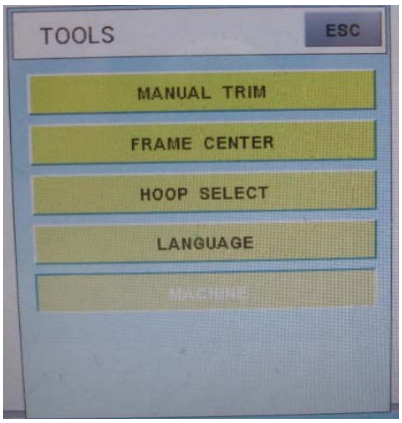
1) Before turn on the machine, checking X-Frame movement whether theris is any interruption or no (limit sensor, sensor bracket, dust, etc) If there is any interruption, remove obstacle for moving X-F

3. Machine motion TEST and Running Test.

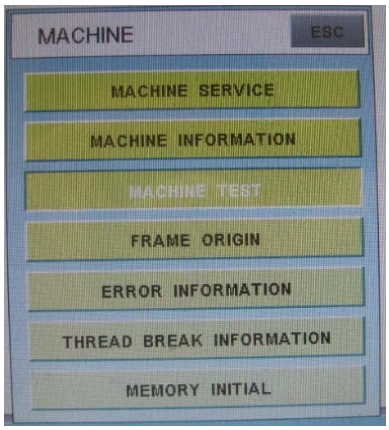
1) After fixing machine, perform machine motion test.

If there is any problem, connect to SWF agent for solving problem.

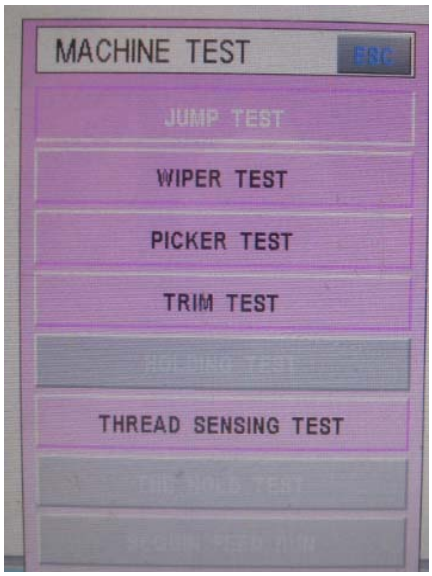
TOOLS -> MACHINE



MACHINE TEST



TEST MENU



Perform each test function whether machine works normally or not.

(JUMP TEST, WIPER TEST, PICKER TEST, TRIM TEST, THREAD SENSING TEST)

4. Checking and adjusting needle position.

* Checking needle position : First, change a color as placing that middle needle bar is on center. Ar

checking needle position as downing middle needle bar. (Degree of Main shaft is between 130 and

* In case needle position is not normal, please adjust needle position again. Reference [Picture 1, a

How to adjust needle position, in case Front and back of needle position is not good.

1)Degree of Main shaft is between 130 and 140°.

2)Release 3 Head rail screws

to use 3mm T-wrench and "-" driver

When disassemble middle head rail screw, presser f

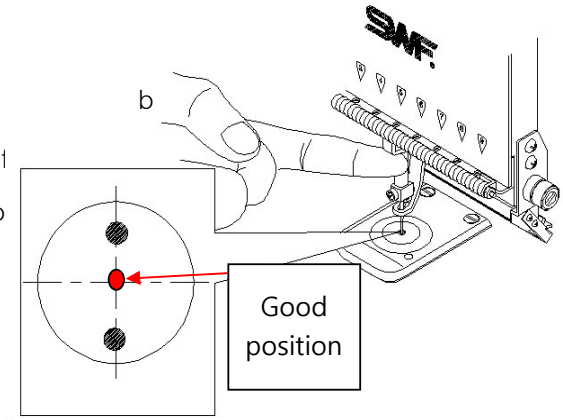
of 3,4 needle bar is prevented. So, down presser fo

of 3,4 needle bar, and release screw.

Reference to [Picture-2]

* Confirm whether there is head rail gauge beteen

head Rail and Head, or not.



[Picture 1]

①In case head rail gauge exist

a) Remove head rail gauge.

②In case head rail gauge doesn't exist.

a) Replace head rail to use 3mm T-wrench and

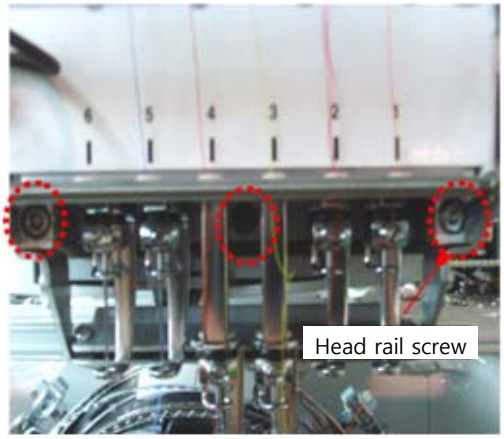
"-" driver.

* The sort of thickness of head rail

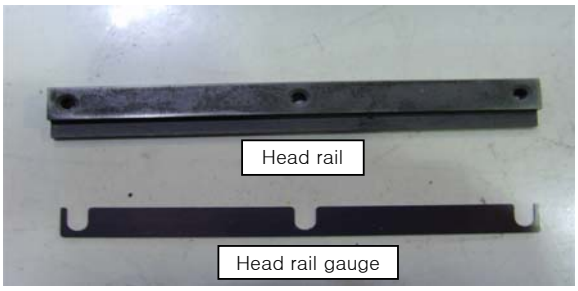
Standard:5.4mm

(-)gauge[special gauge]:5.3mm,5.2mm

3) Assemble head rail screws.



[Picture 2]



How to adjust needle position, in case left and right of needle position is not good.

* Checking needle position : First, change a color as placing that middle needle bar is on center. Ar

checking needle position as downing middle needle bar.

* Reference to [Picture-3]

How to adjust left and right needle position

1) Disassemble 5 screws of Arm cover (L).

Reference to [Picture-4]

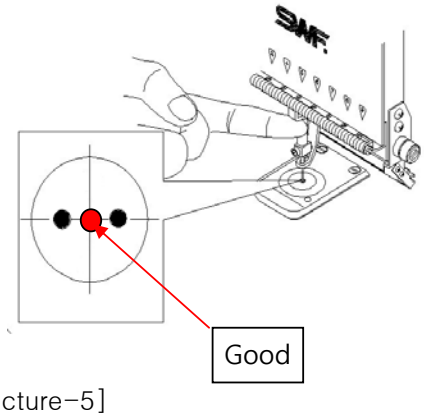
2)Release color change fixing bolt(two) a little,

(to use 4mm T-wrench) and adjust needle position

as moving color change box to left and rig Reference to [Picture-5]

3)After adjusting position, fasten two color change fixing bolts.

4)Assemble 5 screws of Arm cover (L).



[Picture-3]

Caution - If needle position is not correct, it will be caused needle damage. So you have to adjust needle position correctly with head rail gauge of proper thickness.

[Picture 4]

[Picture 5]

5. Checking and adjusting Hook setting condition.

(1) Fixing main shaft to 200 degree, and check a gap between tip of hook and needle.

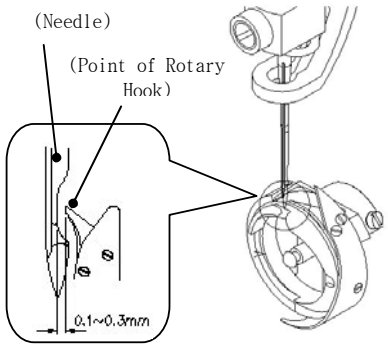
(In case gap is over 0.1~0.3mm, reset distance of hook and needle to use "-" driver.

How to reset : Release 2 of 3 hook fixing screws at middle needle bar position.(at 135, 75 d

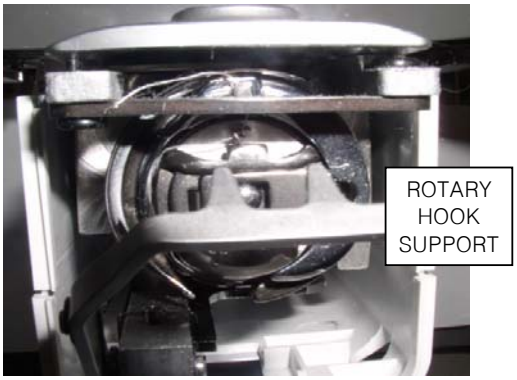
If tip positon of hook is not good or gap between tip of hook and needle is not good, you nee

After reset them, checking distance between tip of hook and needle at 1,6 needle bar.

(Good Distance :0.1~0.3mm) If needle position and gap is good, fasten two hook fixing screw



Tip of hook should be placed on back side of needle, and distance is 0.1~0.3mm.



Convex part of Rotary hook support should be placed on middle of needle, and distance is 0.5~0.7mm with hook

(2) Checking and adjusting position of ROTARY HOOK SUPPORT.

Convex part of Rotary hook support should be placed on middle of needle, and distance is 0.5~0.7mm from hook. If distance is not good, you need to adjust distance as disassembling fixin

6. Checking and adjusting height of Presser foot.

Turn Main shaft to 180 degree, and checking height of presser foot as using presser foot height gauge. If height is not good, you adjust height of presser foot.

※ Presser foot height is adjustable,it depends on fabric Standard :1.0mm, thin fabric:under 0.7mm, Thick fabric: over 1.2mm

[Picture 6]

ㅏ How to se

1) Disassemble Head Face Plate to use "+ " driver. (4 screws)

Reference to [Picture-6]

2) Release presser foot holder screw a little.

Reference to [Picture-7]

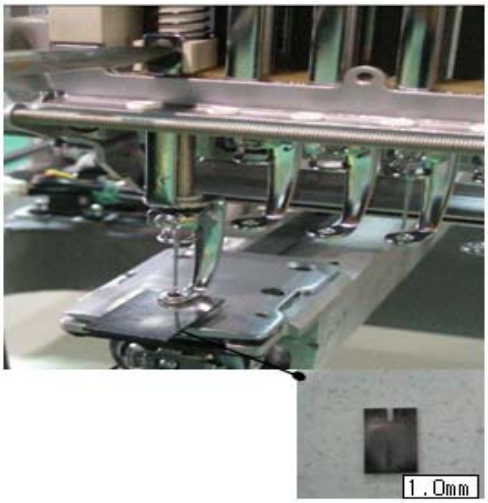
3) When you adjust height of presser foot, degree of main shaf is 180 degree.

Reference to [Picture-8]

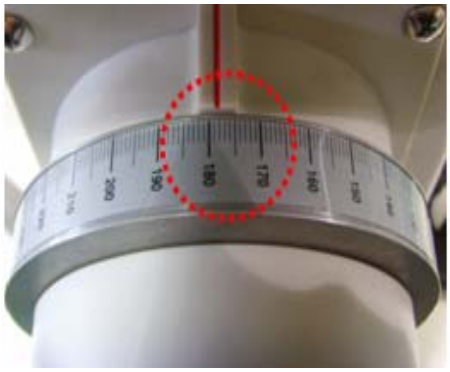
4) Fasten a presser foot holder screw after adjusting height of persser foot with presser foot height gauge.

Reference to [Picture-9]

[Picture 7]



[Picture 9]



[Picture 8]

7. Checking and adjusting Upper and bottom dead point of needle bar.

* Move to middle needle bar on 180 degree(Main shaft)

Check a gap between Jig and Upper dead point after inserting Jig. If there is a gap or Jig is not inserted, you need to reset Upper dead point.

Reference to [Picture-11]

How to set

1) Disassemble head face plate. Release 4 screws

"+" driver

Reference to [Picture-10]

2) Upper dead point setting.

① Main shaft 180°

②Using Bottom dead point jig, please fasten a "needle bar hol

screw" after pushing down needle bar fixing holder.

After fastening a needle bar holder screw, please check whet

Jig move smoothly between bed and "Needle fixed holder".

Reference [Picture 11, 12]

[Picture 10]

Caution) when fastening needle bar fixing screws, pervent needle hare from deformation

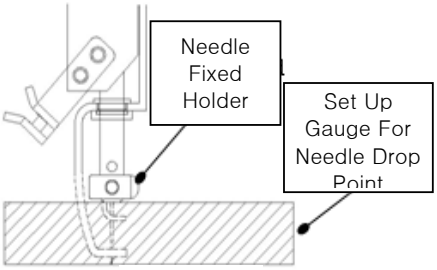
3) bottom dead point

①Main shaft 0°

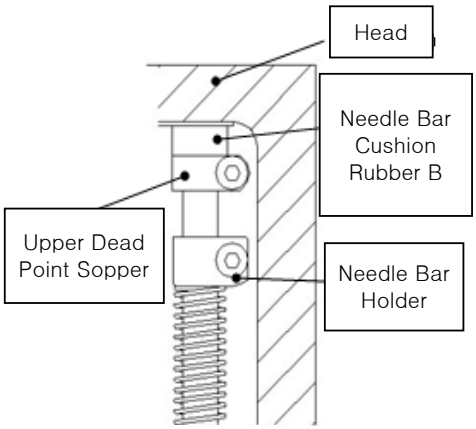
②"Upper damd point stopper" is pushed to "Needle bar cushion rubber B", fasten a screw.

Reference to [Picture-12]

4) After changing needle bar(color) with avoiding reciprocator you check needle bar whether it works smoothly or not.



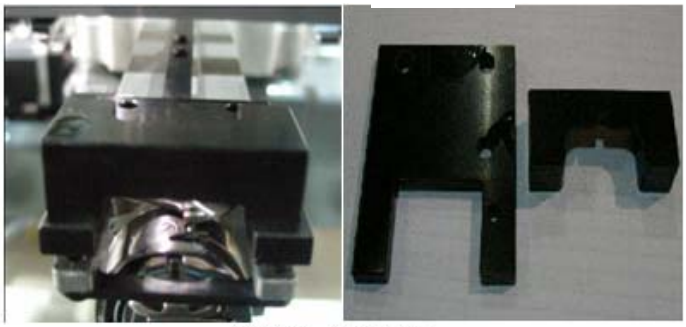
[Picture 11]



[Picture 12]

3. Assemble head face plate

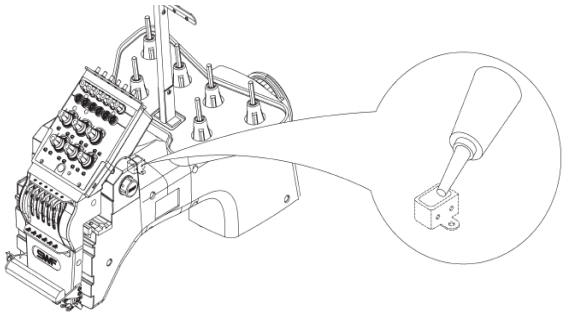
1) Assemble head face plate



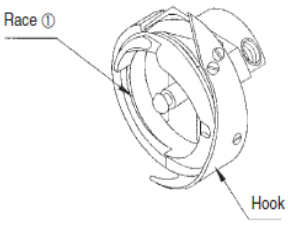
[Bottom dead point Jig

8. TEST work with material.

(1) Lubrication



[Picture 13]



[Picture 14]

When we send a machine, there is no oil in oil box for lubricaiton. So, you need to test machine after putting oil in oil box.
Reference to [Picture-14]

(2) embroidery test

※ Checking a machine condition as testing with fabric and thread of customer, test design. Checking Dadami condition and trimming, thread break.

※ Test a design of customer.

※ When testing to work, teach customer operation and maintenance of machine.

E-COMPACT Report

Country		Model	
Agent		Serial No.	
Company		Version Date	
Date		Technician	

Order	List
1	**Check List of Environment before instalation**
	Status of machine before it arrived at your company ☐ Start from Wood box Opening ☐ When you arrived,machine was moving to inside of factory ☐ Arrived during installation ☐ Arrived during assembly (which setp:) ☐ After whole procudre ☐ etc, ( ) (1) Temperature/ humidity,ambience ☐ good ☐ bad (2) The number of layers : (3) Material of bottom : (4) Levelness of floor ☐ good ☐ bad (5) Speculation of voltage : (6) Input 1P (V) Voltage : 3P (R↔S : V) (R↔T : V) (S↔T : V)
2	**Check List for installation and exterior**
	(1) Safe Arrival - When arrived, check the levelness of of machine ☐ good ☐ bad - Adjust levelness with Bolt and check (if it is not correct at first) ☐ good ☐ bad (2) Check status of frame and debris - Check status of frame at first site ☐ good ☐ bad - Check debris or not ☐ good ☐ bad
3	**Check list for movement TEST and Running TEST**
	After safe arrival,test movement of machine (1) JUMP TEST ☐ good ☐ bad (2) WIPER TEST ☐ good ☐ bad (3) PICKER TEST ☐ good ☐ bad (4) TRIM TEST ☐ good ☐ bad (5) THREAD SENSING TEST ☐ good ☐ bad

4 Check B.D.P status and adjusting

① Before

NEEDLE	1	2	3	4	5	6
NEEDLE POINT	⊕	⊕	⊕	⊕	⊕	⊕

② After

NEEDLE	1	2	3	4	5	6
NEEDLE POINT	⊕	⊕	⊕	⊕	⊕	⊕

※ When insert guage,record it.

5 Check list for Hook timimg and adjusting(good:O, bad:X)

Hook timing 201°, No gapss with Needle, more than 0.3mm,reset it.

① Before ☐ good ☐ bad

② After ☐ good ☐ bad

6 Check list for checking the Pressor Foot and set (good:O, bad:X)

General Head – If needle bar(180°) is out of 1.2mm from Upper Face,reset it.

① Before ☐ good ☐ bad

② After ☐ good ☐ bad

※ Able to adjust ,depends on product (delivery Data : 1.2mm, Thin Fabric:0.7mm, Thick Fabric:1.2m

7 Check list for checking Upper Dead/Needle position and setting

General Head – If Needle point 201°,Upper Dead Point 0° is not correct,reset it.

① Before

NEEDLE	1	2	3	4	5	6
UPPERDEAD POINT	⊕	⊕	⊕	⊕	⊕	⊕
NEEDLE POINT						

② After

NEEDLE	1	2	3	4	5	6
UPPERDEAD POINT	⊕	⊕	⊕	⊕	⊕	⊕
NEEDLE POINT						

8 Sewing TEST.

※ Test with thread and fabrick from your company and check Status of machine
Check Nomalization status,cutting thread
(If the Agent didn't prepare desing,test it with workplace sewing design and check)

※ When test Sewing, check the cutting thread, work timek,missing the first needle and then report

Attach the Sample and Design to report.

※When Sewing TEST,train the worker and manager that how to operate/maintain the machine.